

Work Order ID 88101

Friday, July 27, 2012 10:07:09 AM

88101

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Item ID: D3552-17 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door Prop
 Start Date: 7/26/2012 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 8/9/2012 Req'd Qty: 16.00 *16* Customer:
 Reference: ECN 12-624

Approvals: Process Plan: *nk* Date: *12-07-27* Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3552	J								

160

0.00

160

Purchasing

Purchasing

Memo

0.00

PULL FROM STOCK D3552-17 X 4 B64338, 1 X B65120, 10 X B83585, X
 B69670

AND SEND TO LS TECHNOLOGIES TO HAVE REWORKED PER ECN 12-624

ISSUE P/P: *17549*

SUPPLIER: LS TECHNOLOGIES

CERTIFICATE OF CONFORMITY REQUIRED

170

QC6- Inspect dimensions to drawing

0.00

170

QC

Quality Control

Memo

*MAY NEED DIFF INSPECTION METHOD TO RECEIVING DORR PROPS
 TO ENSURE EXTRA DAMPING FEATURE*

DAS 16 17/08/10

0.00

17/08/10

(410)

*10 only
 burd*

P8 17549

pl 12-07-27

12/07/10

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Item ID: D3552-17

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Door Prop

Stop ***NS2***

Start Date: 7/26/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 8/9/2012 Req'd Qty: 16.00

16

Customer:

Reference: ECN 12-624

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location 261

0.00

180

Packaging

Memo

0.00

Packaging

(101) 12/8/10

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MS 12/08/10

MS 12/08/10

Picklist Print

Thursday, July 26, 2012 10:36:51 AM

Page 1

Work Order ID: 88101

Parent Item: D3552-17

Parent Item Name: Door Prop

Start Date: 7/26/2012

Required Date: 8/9/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC
rev.G DD verf:EC

IPP Rev:B 10.12.03 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-17 Door Prop		Manufactured	No				Each	0.0000		16		7/26/12	10

BB-154-387-156N

rework

Lu

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

List Lots

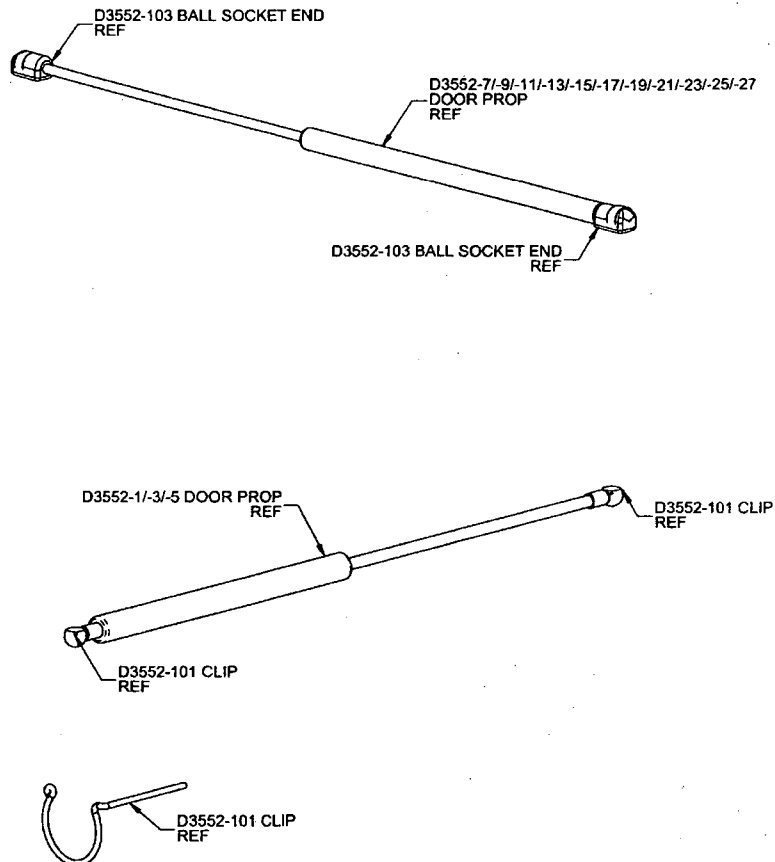
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Criteria : Item ID: d3552-17 All Locations All Warehouses All Quantity

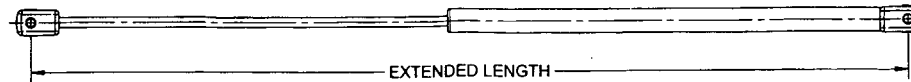
Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D3552-17 Door Prop	Main Warehouse ST272	64338	6/6/2011	4.0000		QC21		
	Main Warehouse ST272	65120	1/19/2012	1.0000		QC21		
	Main Warehouse ST272	83585	4/27/2012	10.0000		QC21		
	Main Warehouse ST276	69670	6/6/2012	1.0000		QC21		
Total:				16.0000				

SPECIFICATION CONTROL DRAWING



RELEASED
2012-07-24

K	ADD "X" TO LS TECHNOLOGIES P/Ns TO DESIGNATE "EXTRA DAMPING" FOR D3552-15/-17/-19/-25/-27. REASON: PART2-209.	MB	12.07.16
J	ADD P/N D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -19. STROKE FOR -15, -17 AND -19 WAS 138/6.06 NOW 154/6.06. EXTENDED LENGTH FOR -15, -17 AND -19 WAS 386/15.2 NOW 387/15.2.	AP	11.12.07
I	ADD P/N D3552-23	RF	11.10.11
H	ADD P/N D3552-21	DC	11.03.10
G	FOR -15, FORCE:300/67.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 388/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-150N WAS B8-167-408-150N	JPH	10.11.01
F	ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE
DRAWN	JE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3552 TITLE DOOR PROP COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
CHECKED	AND		
MFG. APPR.	BE		
APPROVED	AND		
DE APPR.	JE		
DATE	12.07.16	REV. K	SHEET 1 OF 2
		SCALE	NTS



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-220-530-140N
D3552-15	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300NX
D3552-17	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156NX
D3552-19	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060NX
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-167-410-070N
D3552-23	DOOR PROP	190/7.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-070N
D3552-25	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-300NX
D3552-27	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-156NX
2 D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9
3 D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10

D3552-X DOOR PROP

RELEASED
2012-07-24

NOTES:

- 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
- 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21/-23/-25/-27 DOOR PROPS

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO.	REV. K
MFG. APPR.	DE	D3552	SHEET 2 OF 2
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	DOOR PROP	NTS
DATE	12.07.16	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

LS TECHNOLOGIES INC

314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph # (306) 683-5000

Packing Slip

P.O. No.	Date	Invoice #
17549	8/09/2012	8930

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
8/09/2012	Fed-Ex	

Qty	Description
	Parts returned from DART for rework to add Extra End of Stroke Dampening
10	D3552-17 - Increase Dampening and Apply new Dart labels (LST Prt # B8-154-387-156NX)
14	D3552-15 - Increase Dampening and Apply new Dart labels (LST Prt # B8-154-387-300NX)
1	D3552-27 - Increase Dampening and Apply new Dart labels (LST Prt # B8-148-475-156NX)
10	D3552-19 - Increase Dampening and Apply new Dart labels (LST Prt # B8-154-387-060NX)
2	D3552-25 - Increase Dampening and Apply new Dart labels (LST Prt # B8-148-475-300NX)
	Shipping Via FED EX Tracking # 798717499878



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

Aug 09, 2012

10 Units: D3552-17 Carbon Steel Gas Spring *8/10/12*

14 Units: D3552-15 Carbon Steel Gas Spring

1 Unit : D3552-27 Carbon Steel Gas Spring

10 Units: D3552-19 Carbon Steel Gas Spring

2 Units: D3552-25 Carbon Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : July 2012

This product is ROHS compliant.

Purchase Order # 17549

Invoice # 8930

L S Technologies Inc Canada

Nolan Fehr
Manager